Date:

Tuesday, 27/05/2008 12:37:38 PM

Linda Lacelle User:

## **Process Sheet**

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

S.O. No. :

: 39509 **Estimate Number** 

: 11079

P.O. Number

This Issue : 27/05/2008

Prsht Rev. : NC

First Issue **Previous Run**  : //

: 39197

: MACHINED PARTS Type

Written By

Checked & Approved By

Comment

: Est Rev:E Est Rev:f

Re-Format ecn 826

06.12.06

05-11-29 JLM

EC

**Drawing Name** 

: D5953

: INNER FWD SADDLE

Part Number

**Drawing Number** Project Number : D5953 REVB : N/A

: B

**Drawing Revision** 

Material

**Due Date** : 03/06/2008 Qty:

2 Um:

Each

**Additional Product** 

Job Number:



Seq. #:

Machine Or Operation:

Description: Saddle Billet

1.0

D6101007



Comment: Qtv.:

1.0000 Each(s)/Unit

2.0000 Each(s) Total:

D6101-007(7075-T7351)

Size 2.50" x 7.50" X 8.25" (Grain along 7.50")

Batch: \$34875

2.0

HAAS3

HAAS CNC VERTICAL MACHINING #3



Comment: HAAS CNC VERTICAL MACHINING #3

1-Machine as per folio D5953, Ensure Batch Number is entered

2-Machine Keyway

3-Deburr & Tumble

3.0 QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

5.0



HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1





Page 1

W/O:		✓ WORK ORDER CHANGES											
DATE	STEP	PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspector					
				•									
				•									
						-							
Part No		PAR #: Fault Category:	NCR	: Yes	No DQ	٨:	Date: _						
			<u> </u>		N/C Closed	l:	Date: _						
			ON CONFORMANCE		<b>D</b> \								

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B	Verification	Ammunual	Annroyal				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector			
05/3/		Dimension of .500 = 010" of The center steels to .438" was off by .008" under Tokence.		Pasto or skin	25/05/26						
		PINS IS Took Supply in Dioneder. Caldle		Corps appl-	Sol	obliz	U				
	•	Cotton				,					

NOTE: Date & initial all entries

Date: Tuesday, 27/05/2008 12:37:38 PM User: 4 Linda Lacelle **Process Sheet** Drawing Name: INNER FWD SADDLE Customer: CU-DAR001 Dart Helicopters Services Job Number: 39509 Part Number: D5953 Job Number: Seq. #: Description: Machine Or Operation: POWDER COATING 6.0 POWDER COATING **Comment: POWDER COATING** Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 START TIME: OVEN TEMPERATURE: FINISH TIME: INSPECT POWDER COAT/CHEMICAL CONVERSION 7.0 QC3 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION PACKAGING RESOURCE # PACKAGING 1 8.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: FINAL INSPECTION/W/O RELEASE 9.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE Job Completion Wolf New 03

<b>Dart Aerospace Ltd</b>	D	art	Ae	ros	pace	Ltc
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W/O:			V	VORK	ORDER CHANGES	)				
DATE STEP		PR	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					1					
Dowt No.	_	D4D #	- · · ·					_		
Part No		PAR #:	Fault Ca	itegory: ָ	<u> </u>				Date: Date:	
NCR:			WORK OR	DER N	ON-CONFORMANO					
DATE	STEP	Description of NC		·	ctive Action Section B		Verific	ation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng		Action Description Chief Eng	Sign 8 Date	🙎   Secti	on C	Chief Eng	QC Inspector
								<del></del>		
			1		1	1				

NOTE: Date & initial all entries

DRAWN BY DESIGN DART AEROSPACE LTD CBBW HAWKESBURY, ONTARIO, CANADA APPROVED DRAWING NO. CHECKED REV. B DART D5953 SHEET 1 OF 1 TITLE DATE **SCALE** INNER FWD SADDLE 06.11.07 1:4 DESCRIPTION DATE REV 97.05.06 **NEW ISSUE** Α **INTERACT** INCORPORATE DEO 9102, DEO 9079; ADD 0.363 DIMENSION;  $\phi$ 0.316 WAS  $\phi$ 0.313; ADD TOLERANCE TO R2.000; ADD 0.363 DIM В 06.11.07 06.11.28 CHAMFER 0.075 X 45° ALL AROUND R0.063 0.188 R0.025 0.063 -0.500**BOTH SIDES** 0.313 -B 0.033 X 45 R0.250 DETAIL B SCALE 1:1 CHAMFER (2 PLACES) R1.375 R1.625 <u>/B</u>\ R0.025 5.250 0.760+0.005 '-0.000 B 0.500 4.750 -0.363 0.620 2.375 ENGRAVE PART NO. AND BATCH NO. WITH MIN RAD OF  $\bigcirc$ 0.010 TO MAX **DEPTH OF 0.010** 0 3.053 R0.500-4.580 1.527 R2.250 <u>/B</u>\ 0 0 R2.000+0.020 8.000 Ø0.316 (8 PLACES) 50° 1.250 6 GRAIN DIRECTION DRILL Ø 0.316 THRU Ø0.750 SPOT FACE Ø0.920 SPOT FACE 2.050 (2 PLACES) (2 PLACES) R0.500 R0.660-(O) **D5953 INNER FWD SADDLE**  $\emptyset$  0.438 VIEW A-A (4 PLACES) 0 1.750 0.040 X 45° CHAMFER ALL AROUND 0.500 -- 5.250 -7.000 8.000 NOTES: 1) MATERIAL: ALUMINUM 7075-T7351 PER QQ-A-250/12 (MAKE FROM D6101-007 SADDLE BILLET, 7075)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 ISOMETRIC VIEW

POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3 /B

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

5) BREAK ALL SHARP EDGES 0.010 TO 0.020

1

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SCALE 1:8

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DART AEROSPACE LTD		Work Order:	39509
<b>Description</b> : Inner Fwd Saddle		Part Number:	D5953
Inspection Dwg: D5953	Rev: B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Re	corded Actu	al Dimensio	ons		
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	Ву	Date
Α	0.438	0.443		.443	.443				
В	1.745	1.755		1.750	1.750				
С	5.245	5.255		5.250	5.250				
D	6.995	7.005		7.000	7.000				
E	5.240	5.260		7.000 5.250	5.250				
F	4.745	4.755		4.750	4.70				
G	0.315	0.322		.3/9	319				
Н	1.522	1.532		1.527	1.526				
ı	3.048	3.058		3.052	3.00/				
J	4.575	4.585		4.582	4.580				
K	0.313	0.318		1.318	1.31				
L	0.495	0.505		.501 .505 1.625	.500 .499 1-62 [				
М	0.490	0.510		.505	.499				
N	1.615	1.635		1.625	1.621				
0	7.990	8.010		7.992	7-995				
Р	2.240	2.260		2,250	2.250				
Q	0.307	0.312		,510	1.36				
R	0.760	0.765		,760	.160				
S	0.490	0.510		.482	.501				
T	1.375	1.395		1385	1.381				
U	2.000	2.020		2.004	2.009				
V									
W									
Х									
Υ									
Z	-								
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH			,						
	Acc	ept/Reje	ct						

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ſ	Measured by:	Audited by Ry	
ľ	Date: 08/05/31	Date: 08/06/02	
L	700/07		

Rev	Date	Change	Revised by	Approved
Α	99.04.19 New Issue		RF	
В	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
С	06.12.06	Dimensions L,N,P revised	KJ/EC	
D	07.06.15	Dimension G revised	KJ/JLM	
E	08.04.21	Dimension E revised	KJ/DD	